



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400214-1
Job Sheet 189113



Part No: RBT400214-1

Job Qty: 20 pcs

Part Name: Frame Weld Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	20 pcs	2/15/19		0.00	10.00	Large Fab - 1		JBC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	20 pcs	2/15/19		0.00	0.00	Large Fab - 9		R
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
115	QC 5	20 pcs	2/15/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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			QC 5 - 9		
			QC 5 - 50		EZ
			QC 5 - 30		
150	Outsource - 4 - Anodize	20 pcs	2/15/19	ATG001-VC	5
160	Packaging 2-1 - Receive - B4B	20 pcs	2/15/19	0.00	0.00
			Packaging 2 - 1 - B4B		
			Packaging 2 - 2 - B4B		
			Packaging 2 - 3 - B4B		
			Packaging 2 - 5 - B4B		
			Packaging 2 - 4 - B4B		
			Packaging 2 - 6 - B4B		
			Packaging 2 - 7 - B4B		
			Packaging 2 - 8 - B4B		
			Packaging 2 - 9 - B4B		
			Packaging 2 - 10 - B4B		
			Packaging 2 - 11 - B4B		
			Packaging 2 - 12 - B4B		
			Packaging 2 - 13 - B4B		
			Packaging 2 - 14 - B4B		
			Packaging 2 - 15 - B4B		
			Packaging 2 - 16 - B4B		
			Packaging 2 - 17 - B4B		
			Packaging 2 - 18 - B4B		
			Packaging 2 - 19 - B4B		
			Packaging 2 - 20 - B4B		
			Packaging 2 - 21 - B4B		
			Packaging 2 - 22 - B4B		
			Packaging 2 - 23 - B4B		
			Packaging 2 - 24 - B4B		
			Packaging 2 - 25 - B4B		
			Packaging 2 - 26 - B4B		
			Packaging 2 - 27 - B4B		
			Packaging 2 - 28 - B4B		
			Packaging 2 - 29 - B4B		
			Packaging 2 - 30 - B4B		
			Packaging 2 - 31 - B4B		
			Packaging 2 - 32 - B4B		
			Packaging 2 - 33 - B4B		
			Packaging 2 - 34 - B4B		
			Plex 1/18/19 10:58 AM Dart.lajeunesse.marie		

170 QC 6	20 pcs	2/15/19	0.00 0.00	Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
180 Packaging 3-1 - Stock - B4B	20 pcs	2/15/19	0.00 0.00	QC 6 - 68	MAR 21 2019
				QC 6 - 61	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
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				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 MAR 25 2019

Part Op **100** - Weld -7, -9 and -11 as per DWG. Use fixture RBT400214-1-F.

Descriptions: **110** - QC9- Inspect visual per QSI004- Fusion Welds

115 - QC5- Inspect part completeness to step on W/O

150 - Outsource process-Anodize per QSI017 4.1.10.1 -Issue P/O to ATG; PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400214-11	Adapter	20 pcs (1 ea)	100-Large Fab - Welded Assy-1	5119341
RBT400214-15	Frame	20 pcs (1 ea)	100-Large Fab - Welded Assy-1	5132621
RBT400214-7	Tab	20 pcs (1 ea)	100-Large Fab - Welded Assy-1	5150358
RBT400214-9	Adapter	20 pcs (1 ea)	100-Large Fab - Welded Assy-1	5107251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RBT400214-11	20	10	0
	RBT400214-15	20	6	0
	RBT400214-7	20	0	0
	RBT400214-9	20	10	0

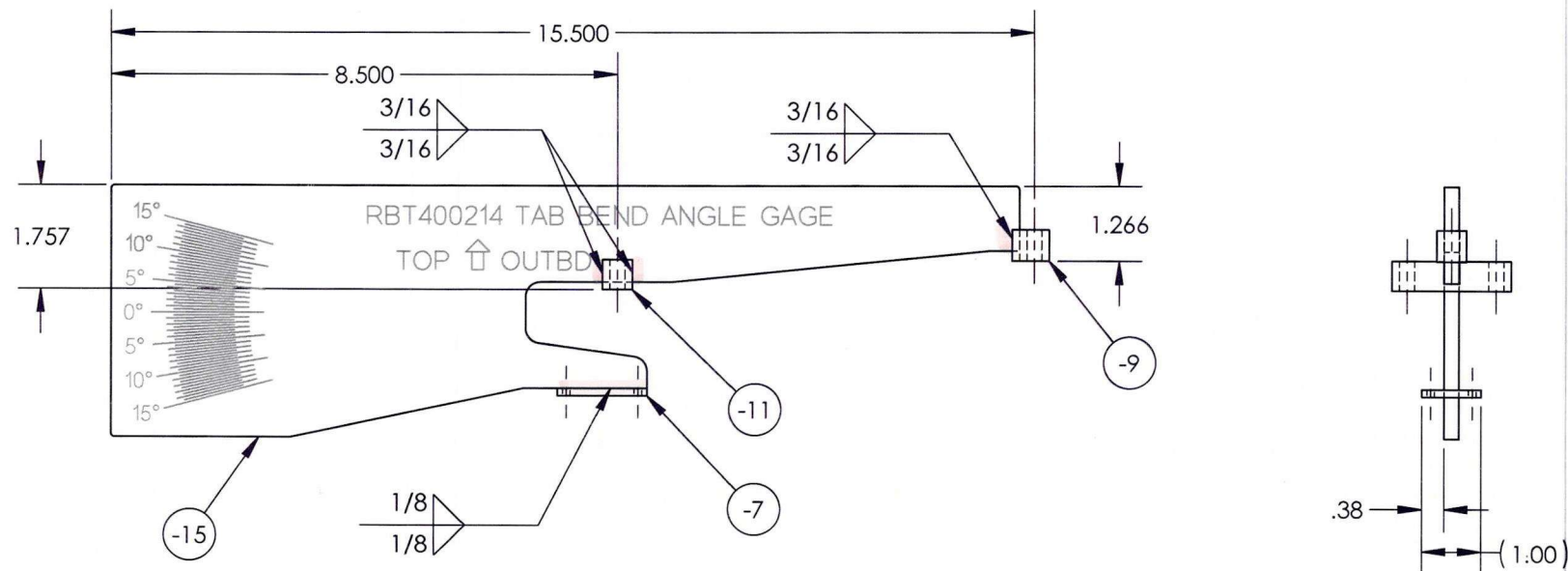
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CREATED -1 WELDMENT, ADJUSTED -11 POSITION UP .046 TO CORRECT ALIGNMENT.	10/30/2007	WP	RW
2		ADJUSTED BEARING SUP .090 TO MATCH PURCHASED UNIT.	1/28/2008	WP	DW
3		CH'D FINISH FROM POWDER COAT SAFETY YELLOW.	4/27/2011	RJC	RW
3A		CH'D -1 FINISH FROM ANODIZE BLACK PER R.W.	8/25/2011	RJC	RW
7	16-0240	-1 DELETED DIMS 15.250, 2.150, .089-.095, .203, 1.550, .694, (.190). ADDED DIMS .38, (1.00). ADDED FIXTURE RBT400214-1-F NOTE.	12/1/2016	DPD	JAG



NOTE:
USE FIXTURE RBT400214-1-F.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189163 MWS
19-01-18

(-1)
FRAME WELDMENT

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-1	REV 7
MAT'L TREAT FINISH SPEC DRAWN BY: CHECKED: OPPTS APPR: QA APPR: APPROVED:	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
MIL-A-8625F, TYPE II, CLASS II COLE CLOUGH ANDERSON LINDSAY GILBERT	USED ON MODEL BELL 407
SCALE 1:3	DATE 4/9/2001
SHEET 2 OF 11	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DARI
AEROSPACE

1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S158035



Part: RBT400214-1

Job No: 189113

Serial No/Batch: S158035

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 03/01/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042784



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042784

PO Date: 3/4/19

Due Date: 3/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189113	RBT400214-1	Frame Weld Mount Outsource process- Anodize per QSI017 4.1.10.1 -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	3/11/19	6 pcs	0 pcs	6 pcs	\$17.85/pcs	\$107.10
2	189178	RBE000-117-3	Base Plate -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/11/19	4 pcs	0 pcs	4 pcs	\$17.85/pcs	\$71.40



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PURCHASE ORDER
PO042784



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189179	RBE000-117-5	Rod -Issue P/O; _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4	-	3/11/19	4 pcs	0 pcs	4 pcs	\$17.85/pcs	\$71.40
MAR 14 2019 DP											
Grand Total:											\$249.90

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/19 1:18 PM dart.Lussier.Patrick



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917448

Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
1 ea	Part: RBT400214-1 Frame Weld Mount Anodize per MIL-A-8625F, Type II, Class 2, Red, Water Sealant, .0004-.0010" (.4 - 1 mils). Job: 24750	Rev: 7 PO: PO042784 Line: 1	
4 ea	Part: RBE000-117-3 Base Plate Anodize per MIL-A-8625F, Type II, Class 1, Clear, Water Sealant .0004-.0010" (.4 - 1 mils) Job: 24751	Rev: B PO: PO042784 Line: 2	
4 ea	Part: RBE000-117-5 Rod Anodize per MIL-A-8625F, Type II, Class 1, Clear, Water Sealant .0004-.0010" (.4 - 1 mils) Job: 24752	Rev: B PO: PO042784 Line: 3	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/3/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			